

Work Order ID 54341

March 4, 2010 10:01:35 AM



Item ID: D3772-1

Revision ID:

Item Name: Back Leg

Start Date: 12/08/09 Start Qty: 20.00

Required Date: 12/16/09 Req'd Qty: 20.00

Reference:

Accept



Setup

Start



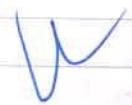
Stop



Cust Item ID:

Customer:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3772	Rev A

100



BAND SAW

Bandsaw

Jeaspa Bandsaw

Memo

0.00

ark 10/03/10

12

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

8.8 10/03/11

12

1

120



QC2- Inspect parts off machine FAI/FAIB

0.00

18,0/03/11

12

1

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3772-1 PAR #: Fault Category: Machined Parts NCR: Yes No DQA: J Date: 10/03/29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: KJ Date: 10/03/30

NCR: <u>54341</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/11</u>	<u>110</u>	<u>all hole are off center by .250". R.E. operator took wrong plug for 2" type. We Have 3 plug but one have .250" thicker than they others sooo forgot to retake the origin. R.C: LACK OF ATTENT. u.</u>	<u>J</u> <u>lesmuz</u>	<u>replace Batch # <u>113494</u> qty 1 - Incorrect plugs disposed of. - Scraps i. destroy.</u>	<u>J.S</u> <u>10/03/11</u>	<u>ark</u> <u>10/03/15</u>	<u>J</u> <u>lesmuz</u>	<u>J</u> <u>10/03/11</u>
			<u>J</u> <u>lesmuz</u>				<u>J</u> <u>lesmuz</u>	<u>J</u> <u>10/03/10</u>

NOTE: Date & initial all entries

Work Order ID 54341

March 4, 2010 10:01:35 AM



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Item ID: D3772-1

Accept



Setup Start



Revision ID:

Item Name: Back Leg

Stop



Start Date: 12/08/09 Start Qty: 20.00



Cust Item ID:

Required Date: 12/16/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10/03/15

12 0

140



Small Fab

Small Fab

0.00

Memo

0.00

12X
 10/03/16

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1-cut tube to lenght as per dwg D3772 2- deburr 3-bend tube as per dwg D3772

7M/F

12

10/03/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54341

March 4, 2010 10:01:35 AM



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Item ID: D3772-1

Accept



Setup Start



Revision ID:

Item Name: Back Leg

Stop



Start Date: 12/08/09 Start Qty: 20.00



Required Date: 12/16/09 Req'd Qty: 20.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



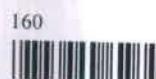
QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionIdentify as per dwg & Stock Location: 254Set Up/
Run Hours
0.00Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Packaging

Packaging

Memo

0.00

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 4, 2010 10:03:32 AM

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Work Order ID: 54341



Parent Item: D3772-1



Parent Item Name: Back Leg

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-09-24 Now on Haas JLM Verified By:EC

Start Date: 12/08/09

Required Date: 12/16/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR1.250W.125						110	f	65.7500	39.7674			

304 RD Tube 1.250 x .125w

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

MAT	65.75	
110316	4.5	
113494	61.25	
	f	
	0.0000	0.0000

33.075 mtl 10/03/10

M316TR1.250W.120

N

Purchased

No

316 RD tubing 1.250 x .120w

A.

MF 10-3-24

DART AEROSPACE LTD	Work Order:	54341
Description: Back Leg	Part Number:	D3772-1
Inspection Dwg: D3772	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

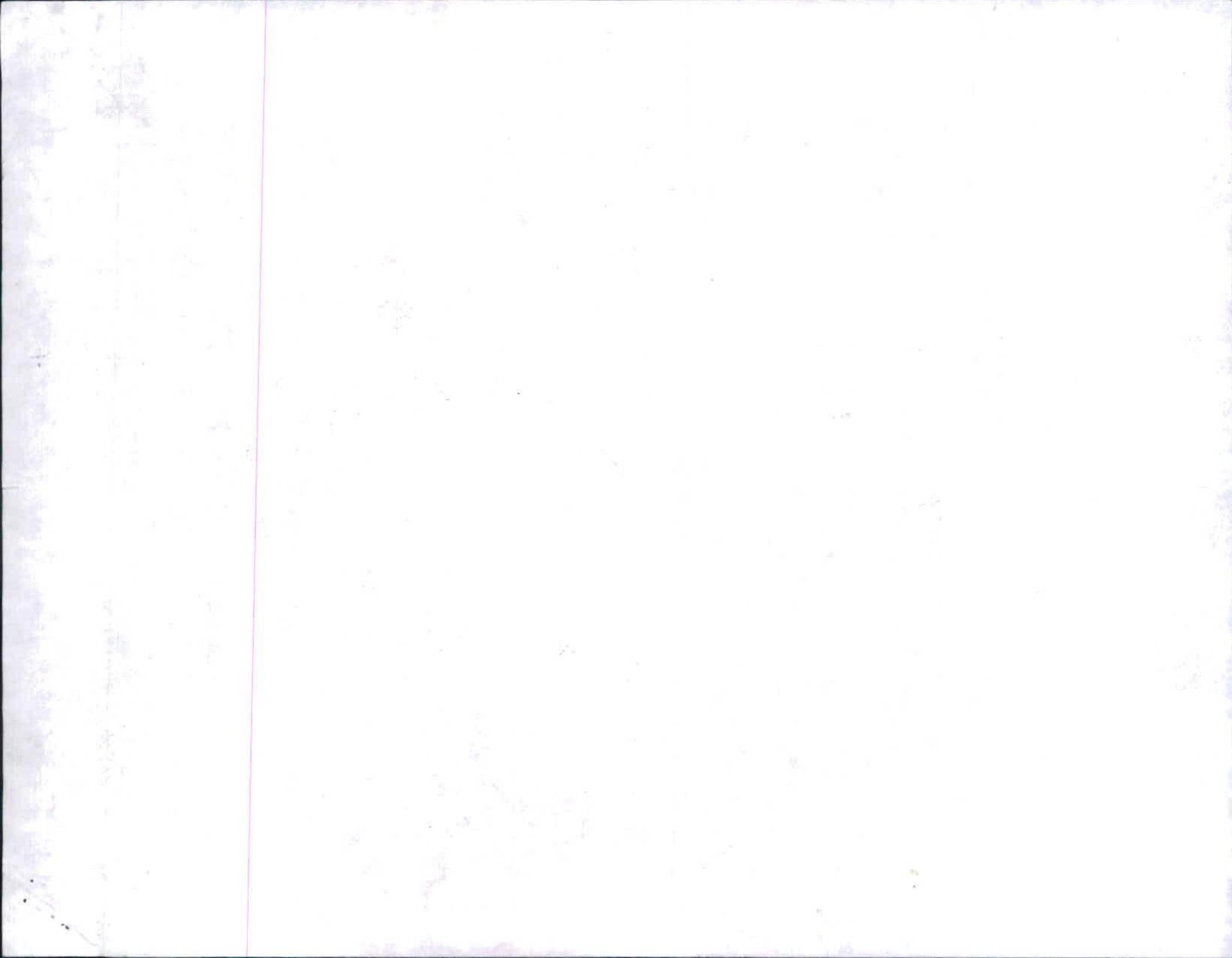
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	+/-0.030	498	✓			
1.70	+/-0.030	1.699	✓			
Ø0.257	+0.006/-0.001	.260	✓			
12.56	+/-0.030	12.56	/			
Ø0.323	+0.006/-0.001	.325	✓			
0.61	+/-0.030		N/A		JPF	10.03.16
Ø0.323	+0.006/-0.001	.325	✓			
Ø1.250	+/-0.010	1.240	✓			
0.125	+/-0.010	115	/			
3.75	+/-0.030		N/A		JPF	10.03.16
1.10	+/-0.030	1.098	/			
0.38	+/-0.030		N/A		JPF	10.03.16.
Ø0.323	+0.006/-0.001	.325	✓			

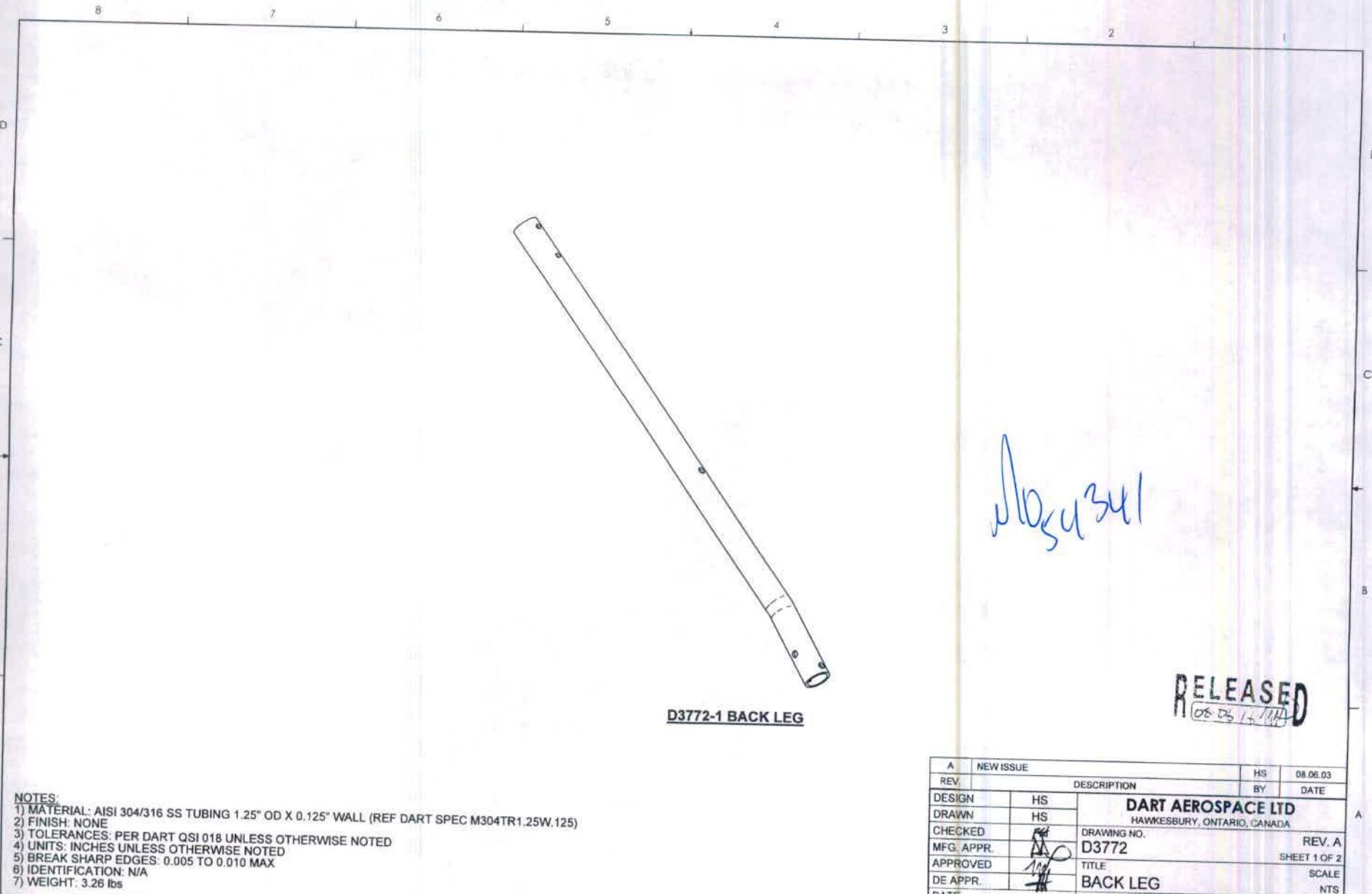
Measured by: SB
Date: 19/03/11

Audited by:	<u>SNL</u>
Date:	10/03/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.10.17	New Issue	KJ/DD	
B	09.05.19	Dimensions 22.00 & 10° removed	KJ	





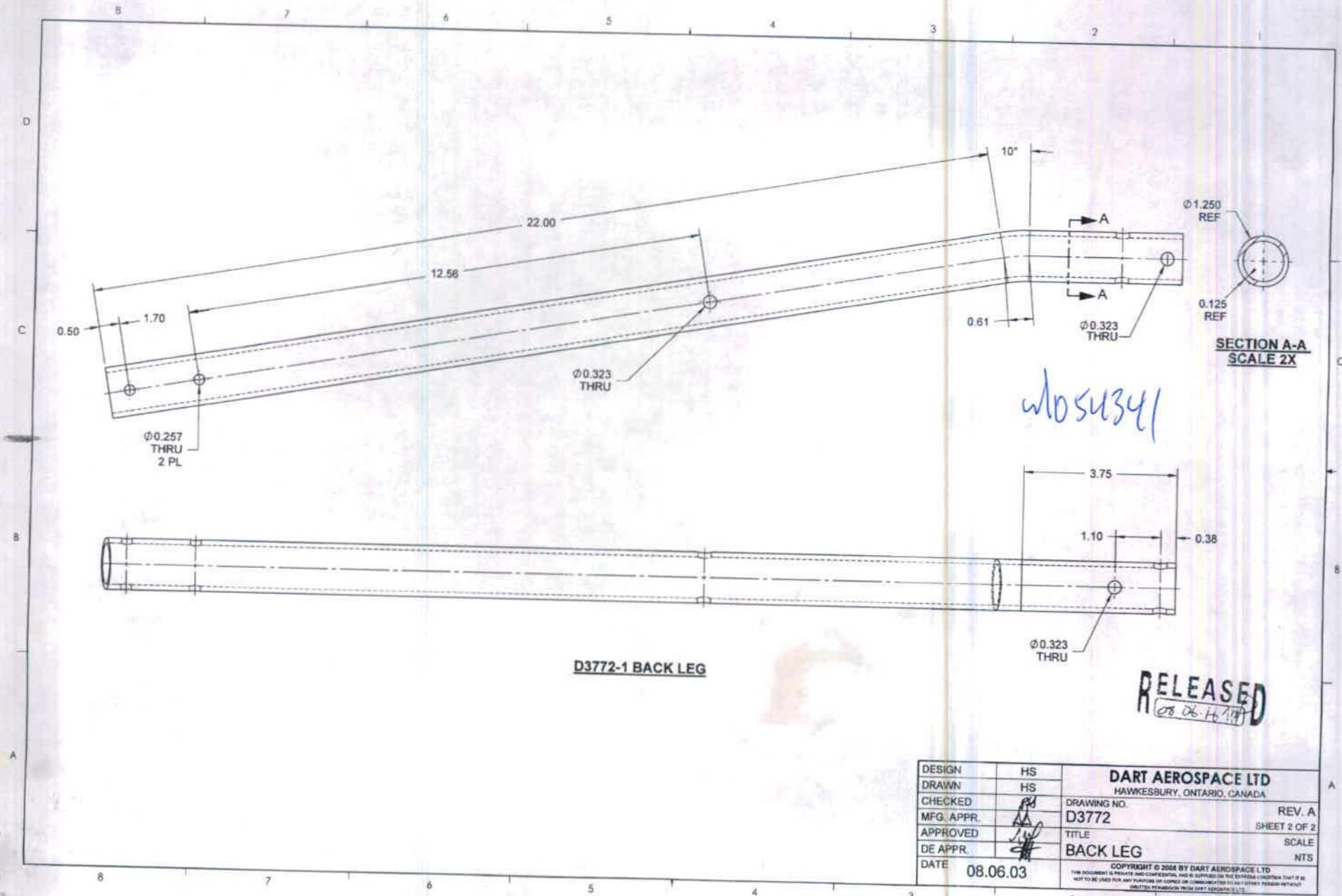
NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION		BY
DESIGN	HS		DART AEROSPACE LTD
DRAWN	HS		HAWKESBURY, ONTARIO, CANADA
CHECKED			
MFG. APPR.			REV. A
APPROVED			SHEET 1 OF 2
DE APPR.			
DATE	08.06.03	SCALE	NTS

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DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AA</i>	D3772	SHEET 2 OF 2
APPROVED	<i>JW</i>	TITLE	SCALE
DE APPR.	<i>CH</i>	BACK LEG	NTS
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